

17-4 R.375

Work Order ID 95751

January-18-13 10:24:25 AM

95751

Page 1

Item ID: D4749-1

Revision ID:

Item Name: Spacer

Start Date: 1/16/13

Start Qty: 10.00

Required Date: 1/31/13

Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MJSDate: 13-01-21 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4749

A

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FB & DWG FOLIO REV: N/ADWG REV: A

2-DEBURR AS REQUIRED

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

13-01-22 20 0

13-01-22 20 0

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
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Work Order ID 95751***95751***

Page 2

January-18-13 10:24:25 AM

Item ID: D4749-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 1/16/13

Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/31/13

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

13-1-23

20 pcs

DAS
0-
9-88

130

Identify as per dwg & Stock Location: 87122

0.00

130

Packaging

Memo

0.00

Packaging

13/01/15 (20)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/1/28

1301-28

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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Picklist Print

January-18-13 10:24:24 AM

Page 1

Work Order ID: 95751

Parent Item: D4749-1

Parent Item Name: Spacer

Start Date: 1/16/13

Required Date: 1/31/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12.11.27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.375 17-4 SS ROUND BAR .375"		Purchased	No				f	16.8960		.646' 0.31		13-01-22	

Location

Loc Qty

Loc Code

MAT030

16.896

121546

16.896

.646'

NCR: Yes / No

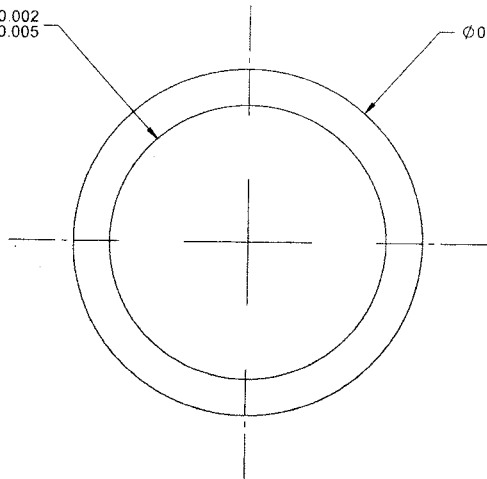
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

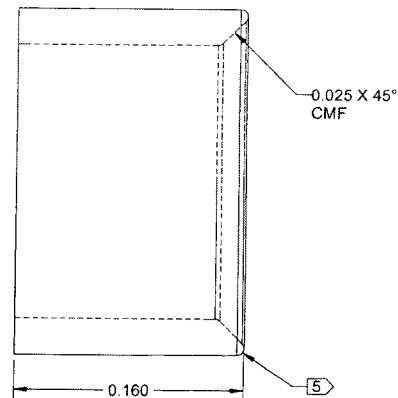
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$\varnothing 0.194^{+0.002}_{-0.005}$ $\varnothing 0.245^{+0.000}_{-0.005}$



D4749-1 SPACER



SUPPLY
TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CANCELLMENT
WITHOUT NOTICE
BY ORDER
95751 MLO
1301-21

RELEASED
2012-12-06

NOTES:

- 1) MATERIAL: 17-4 PH / S17400/ TYPE 630 SS ROUND BAR PER AMS 5643 / ASTM A564
REF DART SPEC. M17-4-R.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 lb

A	NEW ISSUE	AP	12.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4749	SHEET 1 OF 1
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	SPACER	NTS
DATE	12.11.22	<small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	